Work Order Tuesday, October 26	ID 126150 8, 2014 11:30:28 AM		*126	150*		5	hip	100	day	Page 1
Revision ID:	536-13 sket Fwd	-	Accept	*N900	<u>040</u>	100)* ·	Setup Sta Sto	17	S1* S2*
Start Date: 10/ Required Date: 10/ Reference:	28/2014 Start Qty: 12.00 28/2014 Req'd Qty: 12.00	*1 <i>2</i> * *1 <i>2</i> *		Cust Item I Customer:	D:					
	rocess Plan: MF	Date: 4-10-28	- Tooling: SPC (Y/N):		ate:	- 	ŀ	Run Sta Sto	D ~1/J	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3536	Rev A									
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as per Deburr if ne		0.00 0.00 Prog Rev: A	2-			<u> </u>		DC 14	1/10/20
¹¹⁰ *11∩*	QC2- Inspect parts off m	achine FAI/FAIB	0.00					ļ	2/01/4	1. 1.
QC Quality Control	Memo		0.00						-/on 19	110 120
120 *1.00 *	QC8- Inspect parts - seco	ond check	0.00				(12)		DAS 38
1 <i>2</i> 0	Memo		0.00				44			9-89

Quality Control

OCT 2 8 2014

DQA:	Date:										***	®A∧ ` ®T	
					WORK ORDER NON-	-C(ONFO	RMANCE / UPD	ATE				AEROSPACE
QA Closed:		Date:							W	ork Order up	date only		
Work Order	·:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Train Graci	•				Rework			Skid-tube 0	Crosstube]	Water Jet	\neg	Engineering
Part No	o				Scrap		1	Machining :	Small Fab	Pro	d. Eng. Coor.		Quality
NCR No	o				Use-as-is Suspected Unapproved		Thern	noforming C	Finishing	Rec/Stor	e/Packaging Supplier		Other
Root				Descr	ription of work order update	ı	Initial	Action		Sign &			- ,
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descripti	ion	Date	Verification		QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre												İ	
Material													
Operator													
Offset/Setup													
Process]											
Supplier													
Training									,				
Transport													
Jnapproved													
						FAI	ULT CAT	EGORY					
Landing	g Gear				General		_			_	_		
	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	P	ressure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	S	iet-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	t [T	emperature/Cure
	Crimp/Kin	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Unqua	alified	Part Lost/Mi	ssing	v	Veld
	Cuffs				Contamination		Instruct	ions Incomplete/Uncl	ear	Part Moved		٦v	Vrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned W	/rong		
	Heat Trea	it.			Cut Too Short		Mislabe	led		Power Loss/S	Surge		Other
	Inspection	n Strip in	Tube		Drawing		Misread	ł					
	Marks/Ch	atter			Drill Holes		Off-set						
	Turning Se	equence			Finish		Out of C	Calibration					
	Turning Sequence Wave/Twist in Tube			Fit/Function		Out of S	equence						

		- PANA				·			
Work Ord				*126	3150*				Page 2
Item ID: Revision ID:	D3536-13			Accept	*N900	04010	7* Se	etup Start	*NS1*
Item Name:	Gasket Fwd							Stop	*NS2*
Start Date: Required Date:	10/28/2014	Start Qty: 12.00 Req'd Qty: 12.00	*1 <i>2</i> * *1 <i>2</i> *		Cust Item 1 Customer:	ID:			
Reference:			. ,						
Approvals:	Process Pla	n:	Date:	Tooling:	D:	ate:	Rı		*NR1*
	QC:		Date:	SPC (Y/N):	D:	ate:		Stop	*NR2*
Sequence ID/ Work Center II	D	Operation Description	Li.	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	-	Reject Insp. Number Stamp
130		Identify as per dwg & Stoo	ck Location:	0.00			,	/	1 //
130 Packaging		Memo	1	0.00			12	14/10	ha XI
Packaging									,

140

QC21- Final Inspection - Work Order Release

0.00

*14**0***

Quality Control

Memo

0.00

ML3 14-10-28 MF-10-29

DQA:	Date:										7	TQ'AC	
					WORK ORDER NON-	-CC	ONFO	RMANCE / U			_		AEROSPACE
QA Closed:		Date	: 			,			V	ork Order up	odate only		
Work Orde	ır.				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
Work Orde		•			Rework	1		Skid-tube	Crosstube	1	Water Jet		Engineering
Part N	0.				Scrap		į	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging		Other
NCR N	0				Suspected Unapproved			Large Fab	Composite		Supplier[
Root			1	Dosc	ription of work order update		Initial	Act	tion	Sign &		1	
Cause	Dat	ė Step	Qty	Desci	or non-conformance		iief Eng	Í	ription	Date	Verification	,	QC Inspector
Design	Dat	e Jacep	Qty		of non-comormance		ilei Liig	Desci	прион	Date	Verification	<u>'</u>	QC III3pector
Doc/Data													
Equip/Tooling	\dashv				·								
Handling/Pre													
Material	\dashv	İ							•				
Operator									·				
Offset/Setup													
Process													•
Supplier													
Training													
Transport													
Jnapproved													
						FAU	ULT CAT	TEGORY					
Landin	g Gear				General						-		
L	Bendir	ng			Bend		Folio/P	rogram		Outside Dim	ensions	_	Pressure/Forced
L	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
L	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	t		Temperature/Cure
<u> </u>	Crimp,	/Kink/Ripple	e/Wave		Burrs	Щ	Inspecti	on Incomplete/Ur	nqualified	Part Lost/Mi	ssing	_	Weld
	Cuffs				Contamination		•	ions Incomplete/U	Jnclear	Part Moved			Wrong Stock Pulled
	Crushi	-			Countersink	Щ	_	ned/off center	<u>_</u>	Positioned W			
ļ	Heat T				Cut Too Short		Mislabe			Power Loss/	Surge		Other
1	_	tion Strip in	Tube	<u> </u>	Drawing	-	Misread	I					
		/Chatter			Drill Holes	-	Off-set						
	_	g Sequence			Finish	Щ	ł	Calibration					
	Wave/Twist in Tube			Fit/Function		Out of S	iequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print

Tuesday, October 28, 2014 11:30:27 AM

Work Order ID: 126150

126150

Parent Item:

D3536-13

D3536-13

Parent Item Name: Gasket Fwd

Start Date: 10/28/2014

Required Date: 10/28/2014

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No	*		100	sf	171.9341	0.8269	12			1 1
*MNFO60 NEOPRENE SHEET 0.063									**			Dely	10/28

Location Loc Qty Loc Code MAT052 171.9341 2.3 M126546 7.66667 169.6341

QA:	···	Date: WORK ORDER I				ION-CONFORMANCE / UPDATE							DART	
QA Closed:		Date:			WORK ORDER NON	-((JINFUI	RIVIAINCE / U		Vork Ord	er up	date only		AEROSPACE
Work Orde	r·		.,		DISPOSITION				AGAINST D	EPARTN	ENT/	PROCESS		
Part N	0.			:	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Rec		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root				Desci	ription of work order update		Initial	Act	tion	Sign	&			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Dat	e	Verification	n	QC Inspector
resign roc/Data quip/Tooling landling/Pre Material liperator offset/Setup rocess upplier raining ransport														
						FAI	ULT CAT	EGORY		- 1	الــــــــــــــــــــــــــــــــــــ			
Landin	g Gear				General									
	Crimp/Kink/Ripple/Wave Cuffs Crushing Crushing Cut Too Short Inspection Strip in Tube Marks/Chatter Turning Sequence Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration			Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge				Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
	Wave/Twist in Tube Fit/Function		Fit/Function		Out of S	equence								

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PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 21.15 17.65 13.40 9.15 - 0.90 **-** 5.65 1.89 DETAIL A 3.90 ø0.19 (TYP 3 PLS) DATE 06 CHECKED D3536-11 GASKET \triangleright 5 6 3 32.90 06.10.25 29.40 27,40 -23.90 18.98 D3536 GASKET DRAWING NO. NEW ISSUE 14.07 DART 0.90 AEROSPACE PORT HADLOCK, 1.89 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) DETAIL A 3.90 14.00 2) FINISH: NONE **Ø**0.19 PART IS SYMMETRICAL ABOUT &
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED 3) (TYP 4 PLS) 20.00 D3536-13 GASKET 5) ALL DIMENSIONS ARE IN INCHES PURPOSE 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER 7) SEE PAGE 6 FOR DETAILS AND SECTION SHET 욹 NC. COPIED SCALE 아 6 1:10

DQA: Date:	TR'AC
WORK ORDER NON-CONFORMANCE / UPDATE	AEROSPACE
QA Closed: Date: Work Order upd	late only
Work Order: DISPOSITION AGAINST DEPARTMENT/P	PROCESS
Rework Skid-tube Crosstube	Water Jet Engineering
Part No. Scrap Machining Small Fab Prod.	. Eng. Coor. Quality
Use-as-is Thermoforming Finishing Rec/Store,	e/Packaging Other
NCR No Suspected Unapproved Large Fab Composite	Supplier
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or non-conformance Chief Eng Description Date	Verification QC Inspector
Design	
Doc/Data	
Equip/Tooling	
Handling/Pre	
Material	
Operator	
Offset/Setup Offset/Setup	
Process	
Supplier	
Training	
Transport	
Unapproved	
FAULT CATEGORY	
Landing Gear General	. 🗀 .
Bending Bend Folio/Program Outside Dimen	· ·
Centre Not Concentric BOM/Route Grain Over/Under to	├─
Cracks Broken/Damage/Defect Hardware Part Incorrect	⊢ ' '
Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missi	
Custing Countersink Instructions Incomplete/Unclear Part Moved	Wrong Stock Pulled
Crushing Countersink Misaligned/off center Positioned Wro	
Heat Treat Cut Too Short Mislabeled Power Loss/Su Inspection Strip in Tube Drawing Misread	like Toruer
Marks/Chatter Drill Holes Off-set	
Turning Sequence Finish Out of Calibration	
Wave/Twist in Tube Fit/Function Out of Sequence	

#126150 - 27.98 25.08 18.50 15.00 12.47 2.00 -3.43 1.88 4.00 -Ø0.19 (TYP 2 PLS) DETAIL A



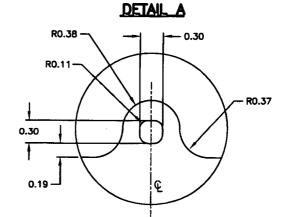


D3536-41 GASKE				
	DIE:	10 A	4 0	
	DO:	20-4	نوا ا	ASR F

- **COTPS

 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



((6	PORT HADLOCK, WA	
CHECKED	APPROVED //	DRAWING NO.	REV. A
 PT PT	#	D3536	SHEET 6 OF 6
DATE		TUL 3TUL	SCALE
06.10.25		GASKET	1:10

DQA:	Date:				_						****	DA'RT	
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE		ork Order up	odate only	\neg	AEROSPACE
					DISPOSITION			AGA	INST D	PARTMENT	/PROCESS		
Work Order	r:								F	· ¬	-		
Part No	O				Rework Scrap Use-as-is		1	Skid-tube Crossi Machining Small noforming Finis	⊢	┥	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR No	0				Suspected Unapproved		THETT	Large Fab Compo	- T]	Supplier		
Root				Desci	ription of work order update	1	Initial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	1	QC Inspector
Design													
Doc/Data	_								•				
Equip/Tooling	_		-										
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process			l		+								
Supplier													
Training					, ,								
Transport						İ							
Unapproved													
						FAI	ULT CAT	regory					
Landin	g Gear				General		_			_			
	Bending				Bend		Folio/F	rogram		Outside Dim	ensions	F	Pressure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct [1	Temperature/Cure
	Crimp/Kir	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing [<u> </u>	Weld
Γ	Cuffs				Contamination		Instruct	ions Incomplete/Unclear	. [Part Moved	[<u> </u>	Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong -		
	Heat Trea	ıt			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
	Inspection	n Strip in	Tube		Drawing		Misread	1					
	Marks/Ch	atter			Drill Holes		Off-set						
	Turning S	equence			Finish		Out of (Calibration					
	Wave/Tw	ist in Tub	oe .		Fit/Function		Out of s	Sequence					

DART AEROSPACE LTD	Work Order:	126150.
Description: Gasket	Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	_		V=5kM-01	
29.40	+/-0.030	29.40	/		T=JEM-06	
27.40	+/-0.030	27.40	~			
23.90	+/-0.030	23.90	/			
18.98	+/-0.030	18.98	/			
14.07	+/-0.030	14.07	7			
9.15	+/-0.030	9.15	_			***
5.65	+/-0.030	5.65	7			
3.90	+/-0.030	3.90	_			
8.00	+/-0.030	8-00	7			
14.00	+/-0.030	14.00	~			
20.00	+/-0.030	20.00	/			
1.89	+/-0.030	(-89	1			
0.30	+/-0.030	120	~			
0.30	+/-0.030	- 3e	-			
Ø0.19	+0.005/-0.001	8.190	~			
						-

DAS

Audited by: 38 OLT 2 8 2014

Date: 0CT 2 8 2014

DAS

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
Α	07.06.13	New Issue	KJ/JLM	E
			()	

Measured by:

Date:

DQA:	Date:				- WORK OPDED NON-CONFORMANCE / LIDDATE								DART
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								AEROSPACE
				DISPOSITION									
Work Order:									,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		PARTMENT,		-,
2 1					Rework		Skid-tube Crosstube			Water Jet		Engineering	
Part No.					Scrap		Machining Small Fab			\dashv	Prod. Eng. Coor.		Quality
NCR No.					Use-as-is Suspected Unapproved		Thermoforming Large Fab		Finishing Composite	_	Rec/Store/Packaging Supplier		Other
												' ' L	
Root				Desci	ription of work order update	1	nitial		tion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	QC Inspector
Design													
Doc/Data		1.											
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Material										İ			
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Offset/Setup]				İ			
Process						1							
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Training													
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Unapproved		<u> </u>	l			L				l		· · · · · · · · · · · · · · · · · · ·	
FAULT CATEGORY													
Landir	ng Gear				General	_	1 .		r				7
-	Bending			_	Bend	Щ	1	rogram		-	Outside Dim	_	Pressure/Forced
-	Centre Not Concentric			BOM/Route	\vdash	Grain			Over/Under tolerar			Set-up	
	Cracks			Broken/Damage/Defect	\vdash	Hardwa		<u> </u>		Part Incorrect		Temperature/Cure	
ļ.	Crimp/Kink/Ripple/Wave			Burrs	_	Inspection Incomplete/Unqualified		· · · · · · · · · · · · · · · · · · ·		Part Lost/Missing		Weld	
-	Cuffs			<u> </u>	Contamination	-	1		mplete/Unclear				Wrong Stock Pulled
-	Crushing			-	Countersink	-	1 ~	ned/off center	nter		Positioned Wrong		. .
}	Heat Treat			<u> </u>	Cut Too Short		Mislabe				Power Loss/Surge		Other
}	Inspection Strip in Tube		-	Drawing	\vdash	Misread			-				
	Marks/Ch				Drill Holes	-	Off-set			-			
	Turning S				Finish	\vdash	4	Calibration		-		····	
ŀ					Fit/Function		Out of S	equence					į

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